

Date: Wednesday, 1/4/2006 2:37:18 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STEP SPACER |
| Job Number : 25395D | |
| Estimate Number : 10356 | |
| P.O. Number : N/A | Part Number : D2279 |
| This Issue : 1/4/2006 S.O. No. : N/A | Drawing Number : D2279 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 25089D | Material : |
| Written By : <u>SEE COMMENT Below</u> | Due Date : 1/25/2006 |
| Checked & Approved By : <u>SEE ABOVE USER</u> | Qty : <u>30</u> Um : <u>20</u> Each |
| Comment : Est Rev: A New Issue 05-11-07 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-------------|--------------------|
| 1.0 | M2024T3S040 | 2024-T3 .040 sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: M19295

| | | |
|-----|-------|-------|
| 2.0 | SHEAR | SHEAR |
|-----|-------|-------|



Comment: SHEAR
 Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50")

JL 06-02-01 30

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2279, use stack of 15

JL 06-02-01 30

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 06-02-01 30

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

MS 06/02/01 30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: Date: 06/02/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:37:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 25395D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

ml 06/02/03 (30)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form As per Dwg D2279

SB 06/02/16 (30)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

060217 30

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/02/18 (30)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

060220 30

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA 5

SB 06/02/23 (30)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/02/24 (30)

Job Completion



060223

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|-----------------------------------|--|--------------|--------|
| DART AEROSPACE LTD | | Work Order: | 25395D |
| Description: Step Spacer | | Part Number: | D2279 |
| Inspection Dwg: D2279 Rev: D | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

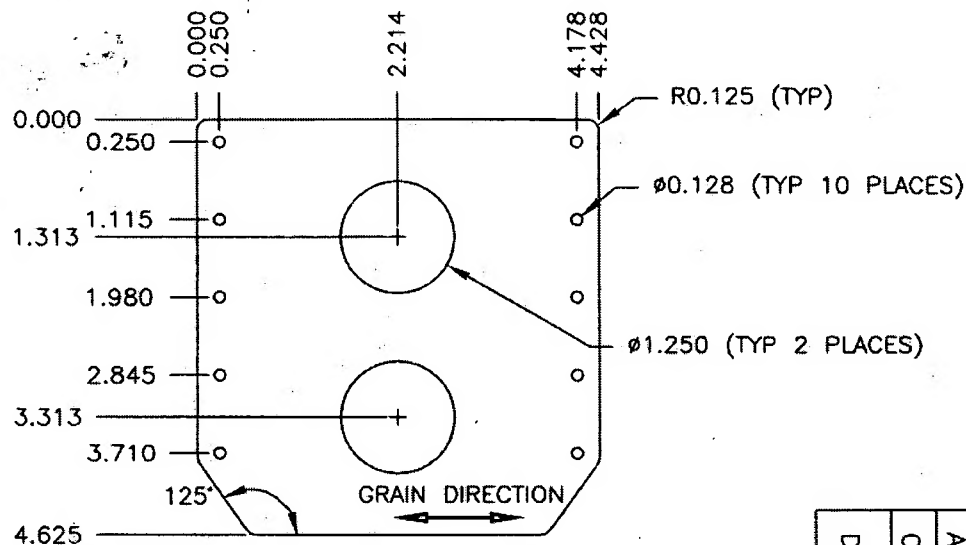
[illegible]

| | | | | | |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L | Audited by: | MS | Prototype Approval: | N/A |
| Date: | 06.02.01 | Date: | 06/02/01 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|---------------------|------------|----------|
| A | 04.10.12 | New Issue P/O D2582 | KJ/JLM | |

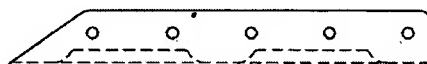
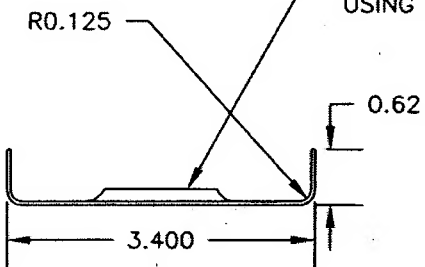


| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. D |
|----------|-------------|--|--------------|
| BW | JP | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 1 |
| KE | JP | D2279 | |
| DATE | TITLE | SCALE | |
| 98.10.05 | STEP SPACER | 1:2 | |
| A | 94.10.13 | NEW ISSUE | |
| C | 94.11.15 | 0.588 WAS 1.607 AND 3.861 WAS 4.881 | |
| D | 98.10.05 | 4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912 | |



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



RELEASED
98.10.08 DS

UNDER REVIEW

98.10.15 JP
DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE

OK JP/10/08

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

UNROLLED
SUBJECT TO AGENCIES
WITH OUT NOTICE

WORK ORDER

NO. 25395D

